

Work Order ID 86463

86463

Page 1

June-29-12 1:27:28 PM

Item ID: D4542-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Retainer, Inner, RH

Stop ***NS2***

Start Date: 29/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/29

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4542	B
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100

100

Waterjet

FLOW CNC Waterjet

6061 .032

Memo

1- Cut as per dwg

Prog rev: B

Dwg rev: B

2- Deburr

110

QC2- Inspect parts off machine FAI/FAIB

110

QC

Quality Control

Memo

SCRAP

Scrap
Material
No good
W

10 0 Jm 12-7-9

0 Jm 12-7-9

Ae
12.07.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130 Identify as per dwg & Stock Location: GA

0.00

130

Packaging

Memo

0.00

Packaging

140 QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MEF
12-07-23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-29-12 1:27:31 PM

Work Order ID: 86463

86463

Parent Item: D4542-2

D4542-2

Parent Item Name: Retainer, Inner, RH

Start Date: 29/06/2012

Required Date: 13/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 12.01.12 New Issue EC verified by:DD IPP REV:B
12.02.24 as per dwg reva DD verf:EC IPP REV:C 12.05.08 as
per dwg revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.032		Purchased	No				sf	247.7760		8.771579			
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M6061T6S 032

**

8.8

Jun 27 09

6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

247.776

118106

46.136

120218

20.13

120285

42.24

121099

139.27

122311

122311

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

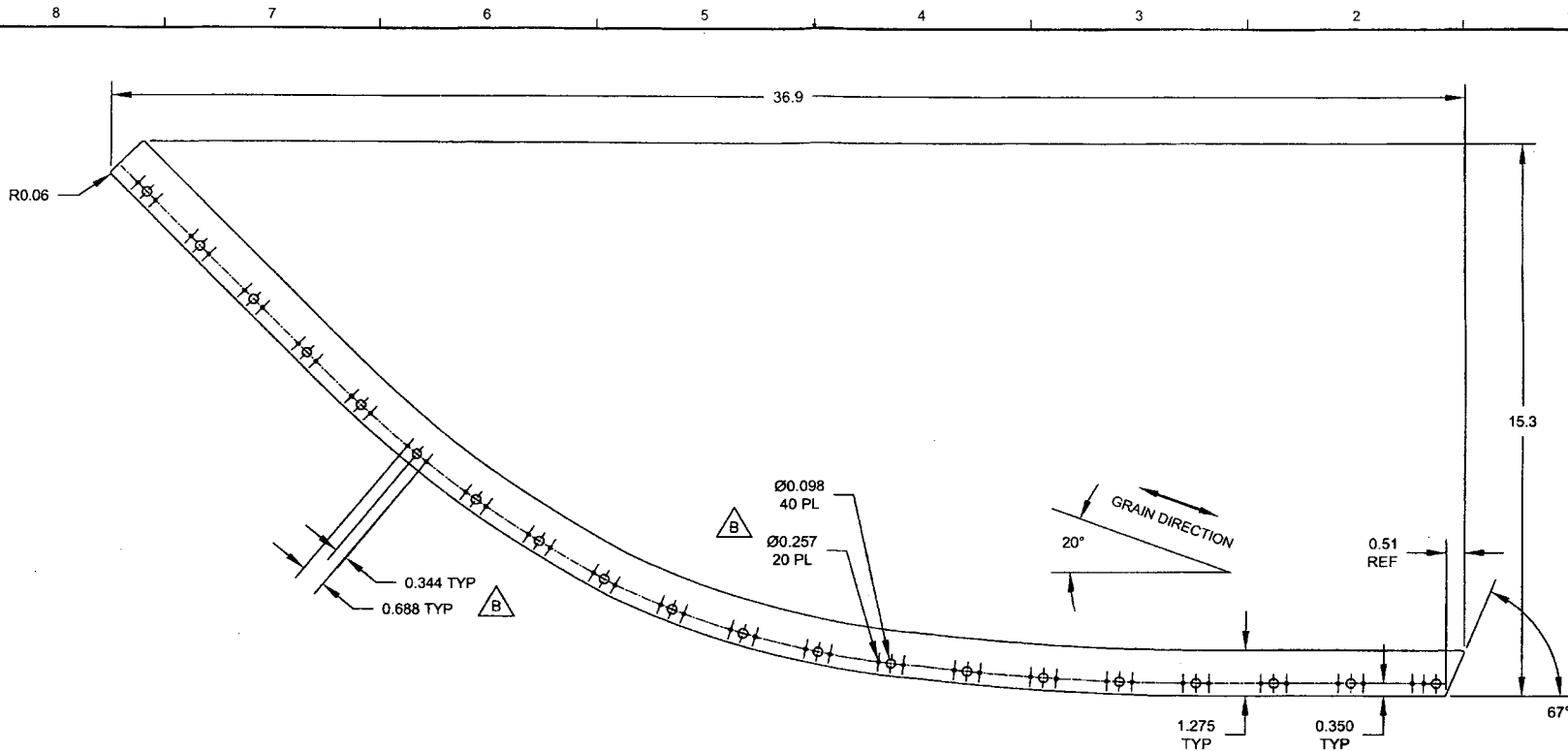
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4542-1 RETAINER, LH INNER
(LOWER)

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061TGS.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs
- 8) PROFILE PER DRAWING FILE "D4542-1-REVB.DXF"

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 80463 MLJ
12/06/29

B	RMV FINISH & ADD HOLES (-1/-2/-3/-5/-7)	CP	12.04.20
A	ADD/MODIFY ORIENTATION MARK (C2-4, C5-6)	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D4542 SHEET 1 OF 5
TITLE SCALE
RETAINER, INNER NTS

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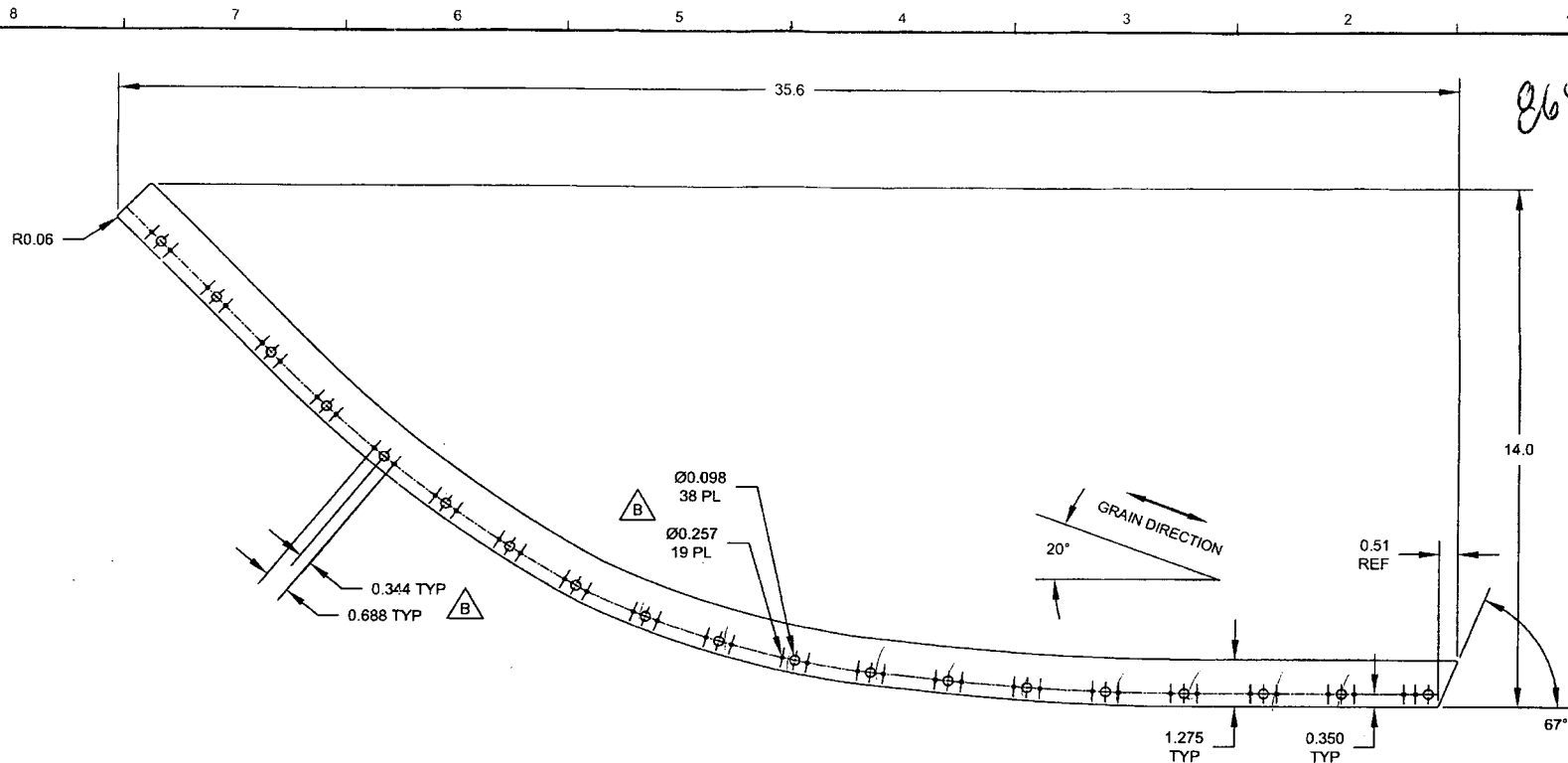
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D4542-2 RETAINER, RH INNER
(LOWER)**

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs
- 8) PROFILE PER DRAWING FILE "D4542-2-REVB.DXF"

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4542	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

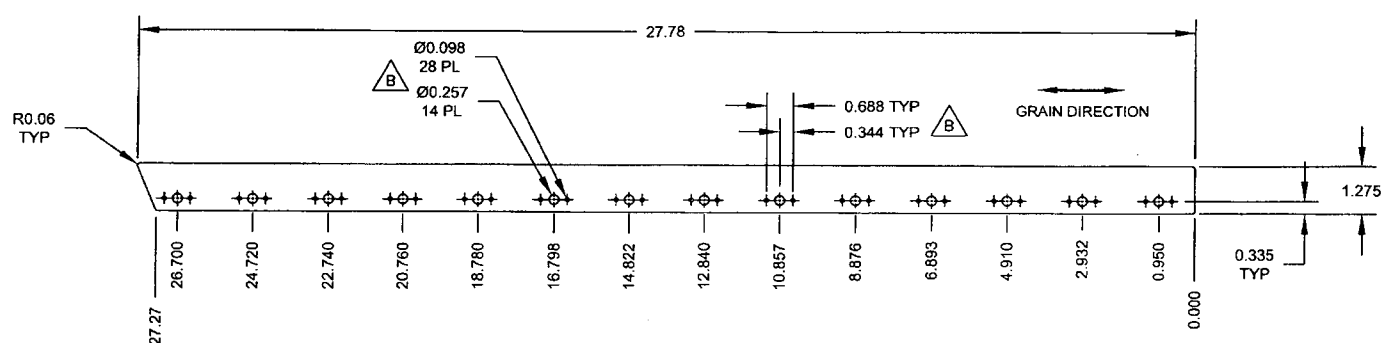
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86463



D4542-3 RETAINER, INNER
(SIDE)

2012-05-07

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.11 lbs
 - 8) PROFILE PER DRAWING FILE "D4542-3-REV8.DXF"

DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	<i>Q</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. B
MFG. APPR.		D4542	SHEET 3 OF 5
APPROVED	<i>Q</i>	TITLE	SCALE
DE APPR.	<i>#</i>	RETAINER, INNER	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

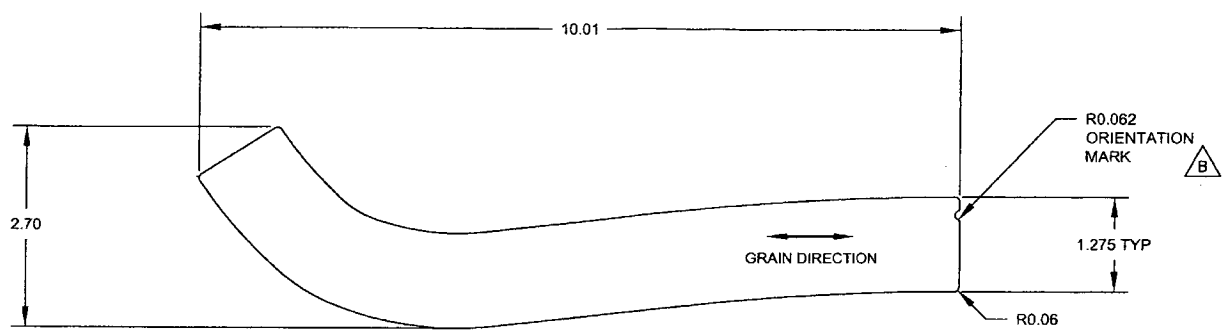
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86463



D4542-5 RETAINER, INNER
(TOP CORNER)

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4542-5-REV8.DXF"

DESIGN	9	DART AEROSPACE LTD	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	ASS	D4542	SHEET 4 OF 5
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DE APPR.	JP	RETAINER, INNER	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

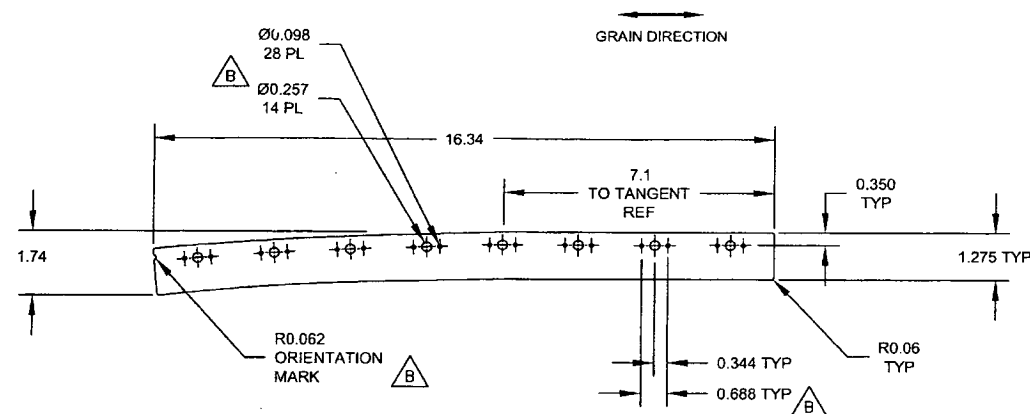
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

26463



D4542-7 RETAINER, INNER
(TOP)

RELEASED
2012-05-07
MP

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs
- 8) PROFILE PER DRAWING FILE "D4542-7-REV8.DXF"

DESIGN	MP	DART AEROSPACE LTD	
DRAWN	MP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	AA	D4542	SHEET 5 OF 5
APPROVED	MP	TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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